

D4634-041 FWD, CENTER CEILING PANEL ASSY

ITEM NO.	QTY. -041	P/N	DESCRIPTION
1	X	D4634-041	FWD, CENTER CEILING PANEL ASSY
2	1	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-047)
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-9 (REF)	MOUNTING NUT (PART OF D4652-7)
7	2	D4652-7	AIR VALVE
8	1	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
9	1	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
10	2	N/A (REF)	SCREW (PART OF D4638-1)
11	2	D4743-1	SPEAKER GRILL
12	8	MS21044-N08	NUT, SELF-LOCKING
13	8	MS24693-BB50	SCREW, CSK 100°
14	8	NAS1149DN832J	WASHER
15	7	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
16	1	50-009-2	GROMMET
17	1	2351-20-27-C3C	DZUS STUD, OVAL HEAD

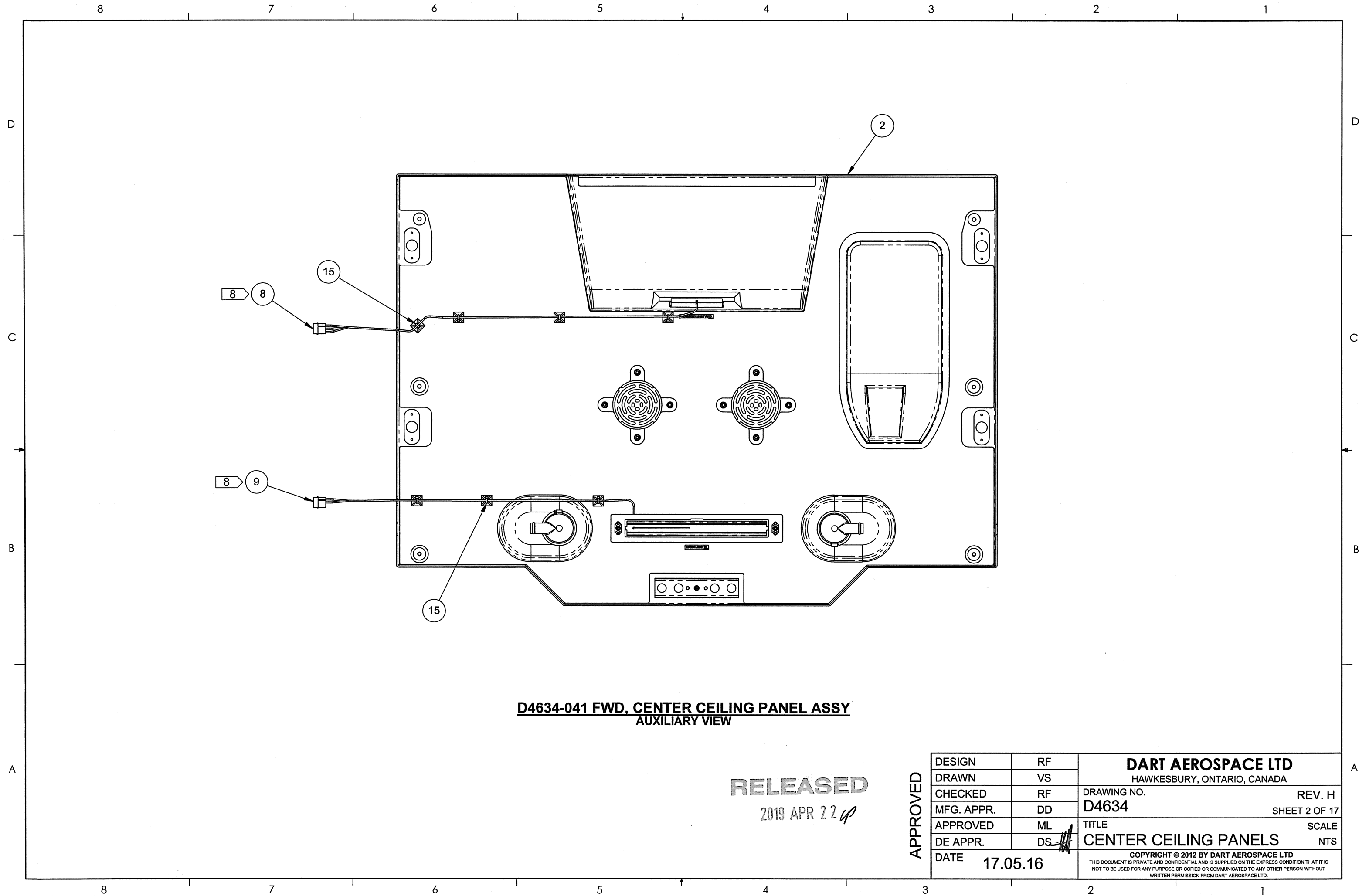
- NOTES:  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE  
7) WEIGHT: 7.0 lbs  
8) INSTALL D4728-047/-051 WIRE HARNESS PER QSI 048

RELEASED

2019 APR 22  
EN 15-591

APPROVED

H	REPLACED D4652-5 WITH D4652-7 (ZN D4-1, D4-3, D4-5) REF CAR18-268; CCR264SS-3-(03) WAS MS20426AD3-(4) (ZN D4-7, D4-8, D4-9), REF CAR 16-153	VS	17.05.16
G	D4652-5 WAS D4652-1 (ZN D4-1, D4-3, D4-5); 10.28 WAS 10.20 (ZN B6-10, B5-12, B5-14); TIE-WRAP & MOUNTING PAD QTY CHANGE; MOUNTING PAD EDGE DISTANCE CHANGE	RF	14.11.28
F	REVISE BOM (ZN D4-7); ADD DIM (ZN B8-9); 10.20 WAS 10.05 (ZN B6-10, B5-12, B5-14); ADD DETAIL V (ZN C4-10, B4-12, C4-14, A4-16); CHANGE PROTRUDE SECTION DIMS TO REF (ZN C7-10, C7-12, C7-14)	RF	14.02.03
E	REVISED BOM (ZN C4-1, C4-3, D4-5, C4-7, C4-8, C4-9); ADDED NOTE 11) (ZN D5-7, A8-7, D5-8, A8-8, D7-9, A8-9); 3.70 WAS 3.83 (ZN C6-11); 1.88 WAS 2.00 (ZN D7-13); 6.13 WAS 6.25 (ZN B6-15); REVISE DETAIL B (ZN A8-16)	RF	14.01.09
D	ADDED PLT1.5M-M (ZN C4-5, C6-6); D5021-1 (ZN D4-7, D5-7); D5021-3 (ZN D4-8, D5-8); D5021-5 (ZN D4-9, B7-9); MPNY-750S-9-C (ZN D4-9, B7-9); Ø0.129 (ZN B4-11, B4-13); DETAIL "U" (ZN C2-17); 3.83 WAS 3.87 (ZN C6-11), 2.00 WAS 2.02 (ZN D6-13), REVISE NOTE 8) & 10) (ZN A8-7, A8-8, A9-9); & NOTE 1) (ZN A8-10, A8-12, A8-14); 3.80 WAS 3.84 (ZN D4-17, B8-17); REMOVED D4694-7/-041/-043/-045/-047, D4647-3/-7/-8; DIMENSION SHIFTED DUE ADDING D5021-1/-3/-5; Ø0.250 WAS Ø0.206 (ZN D6-11, C3-13 & D6-15)	RF	13.12.09
C	REVISE GENERAL NOTES (ZN A8-7, A8-8, A8-9) & BOM (ZN D4-1, D4-3, D4-5, D4-7, D4-8); Ø0.206 WAS Ø0.207 (ZN D6-11, C3-13, C6-15) ADD DIM. (ZN B6-7, B7-7, D7-8, & D6-8)	RF	13.06.18
B	ADDED D4634-141/-143/-145 (ZN B4-7, B4-8, B4-9); REVISE D4634-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADD DETAILS R,S,T SHT 10, 12, 14, 16, 17	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. H
MFG. APPR.	DD	D4634	SHEET 1 OF 17
APPROVED	ML	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
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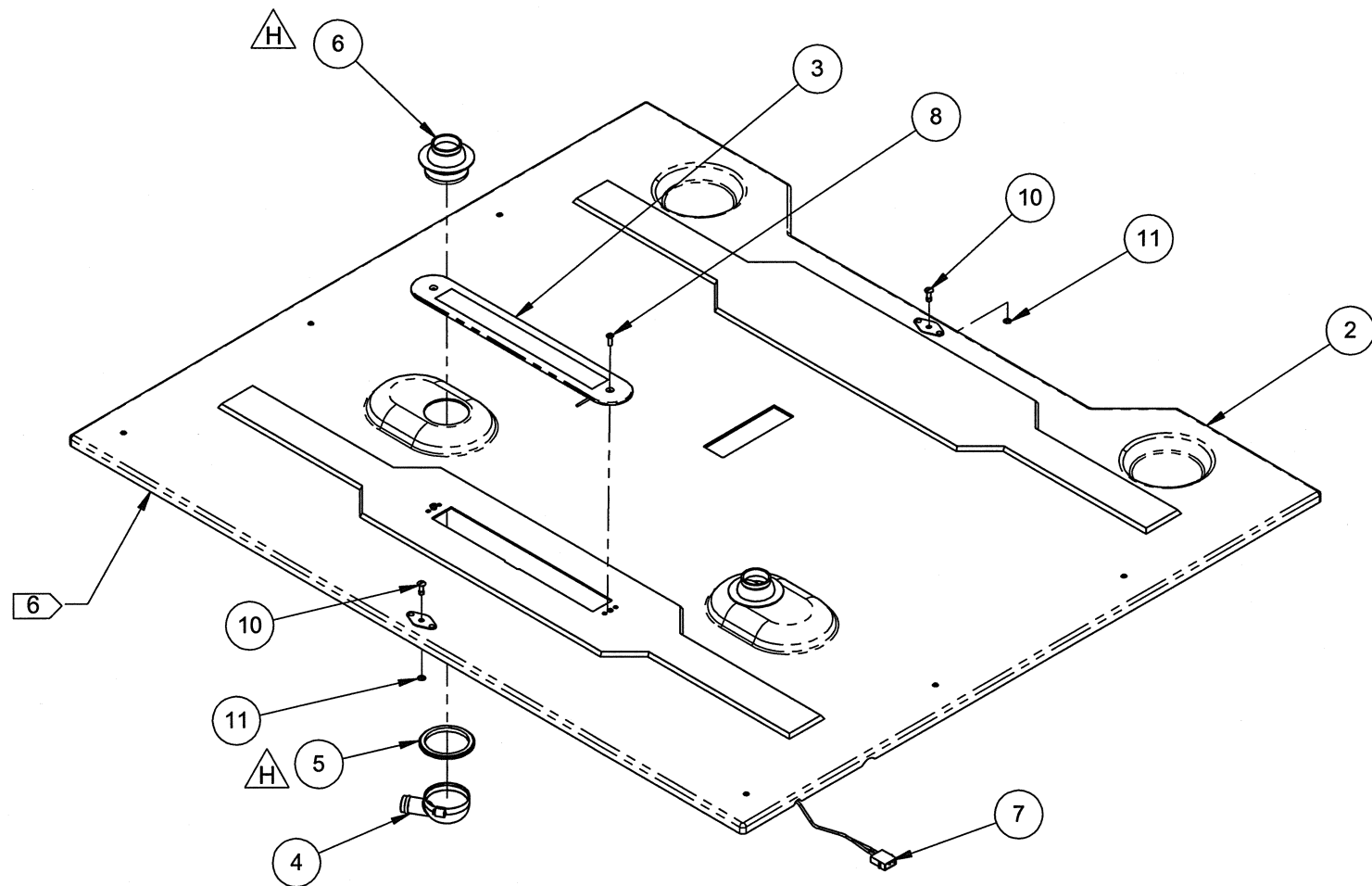


**D4634-041 FWD, CENTER CEILING PANEL ASSY**  
**AUXILIARY VIEW**

**RELEASED**  
2019 APR 22 *CP*

**APPROVED**

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. H
MFG. APPR.	DD	SHEET 2 OF 17	
APPROVED	ML	TITLE	SCALE
DE APPR.	DS	<b>CENTER CEILING PANELS</b>	NTS
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ITEM NO.	QTY. -043	P/N	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-053)
4	2	D4646-1	PLENUM CAP ASSEMBLY
5	2	D4652-9 (REF)	MOUNTING NUT (PART OF D4652-7)
6	2	D4652-7	AIR VALVE
7	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
8	2	N/A (REF)	SCREW (PART OF D4638-1)
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
10	2	2351-20-27-C3C	DZUS STUD, OVAL HEAD
11	2	50-009-2	GROMMET

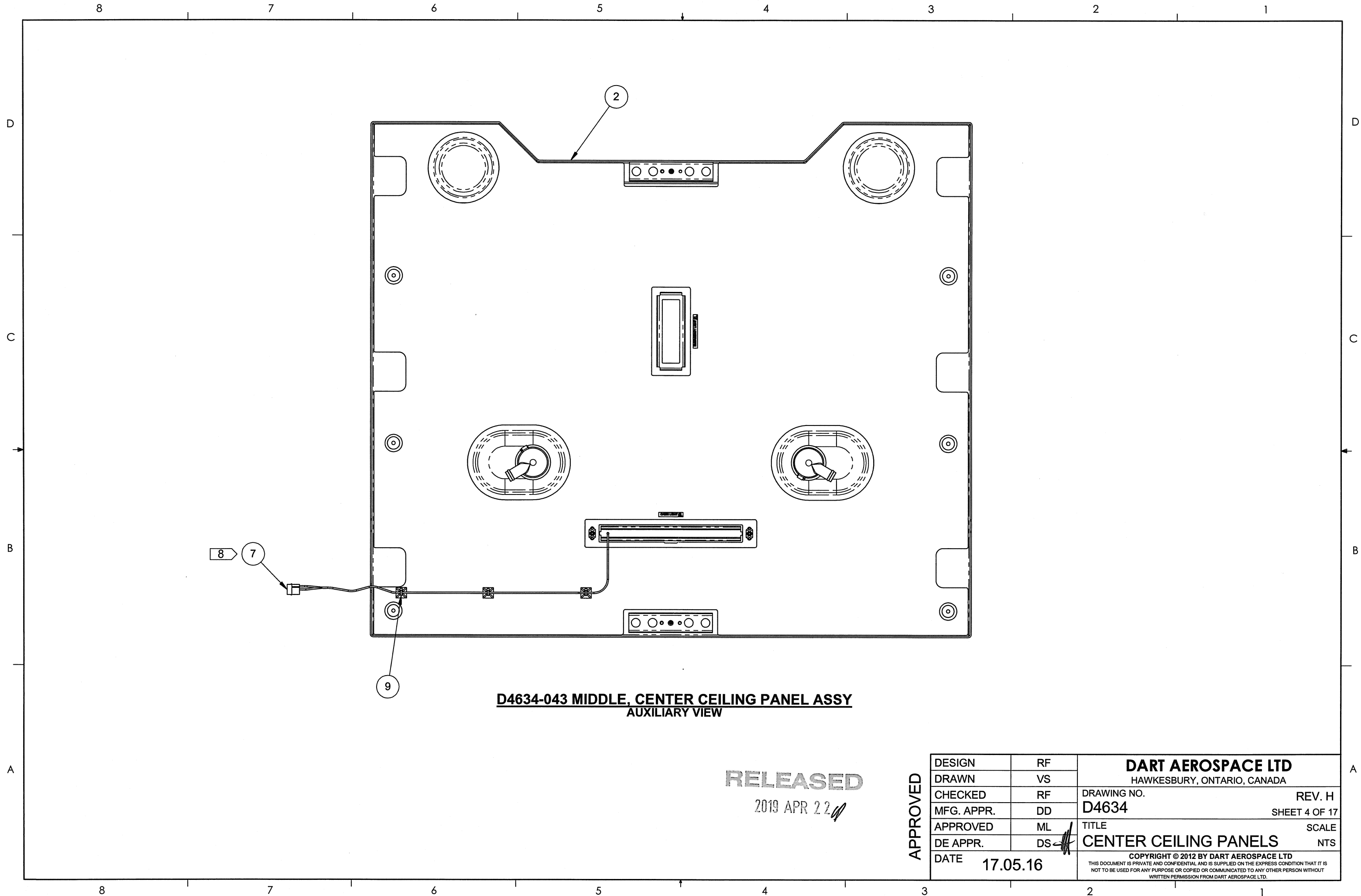
D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
  - 7) WEIGHT: 9.5 lbs
  - 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

RELEASED  
2019 APR 22

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. H
MFG. APPR.	DD	SHEET 3 OF 17	
APPROVED	ML	TITLE	SCALE
DE APPR.	DS	<b>CENTER CEILING PANELS</b>	NTS
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**D4634-043 MIDDLE, CENTER CEILING PANEL ASSY**  
AUXILIARY VIEW

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2019 APR 22

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DRAWN	VS		
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. H
MFG. APPR.	DD	SHEET 4 OF 17	
APPROVED	ML	TITLE	SCALE
DE APPR.	DS	<b>CENTER CEILING PANELS</b>	NTS
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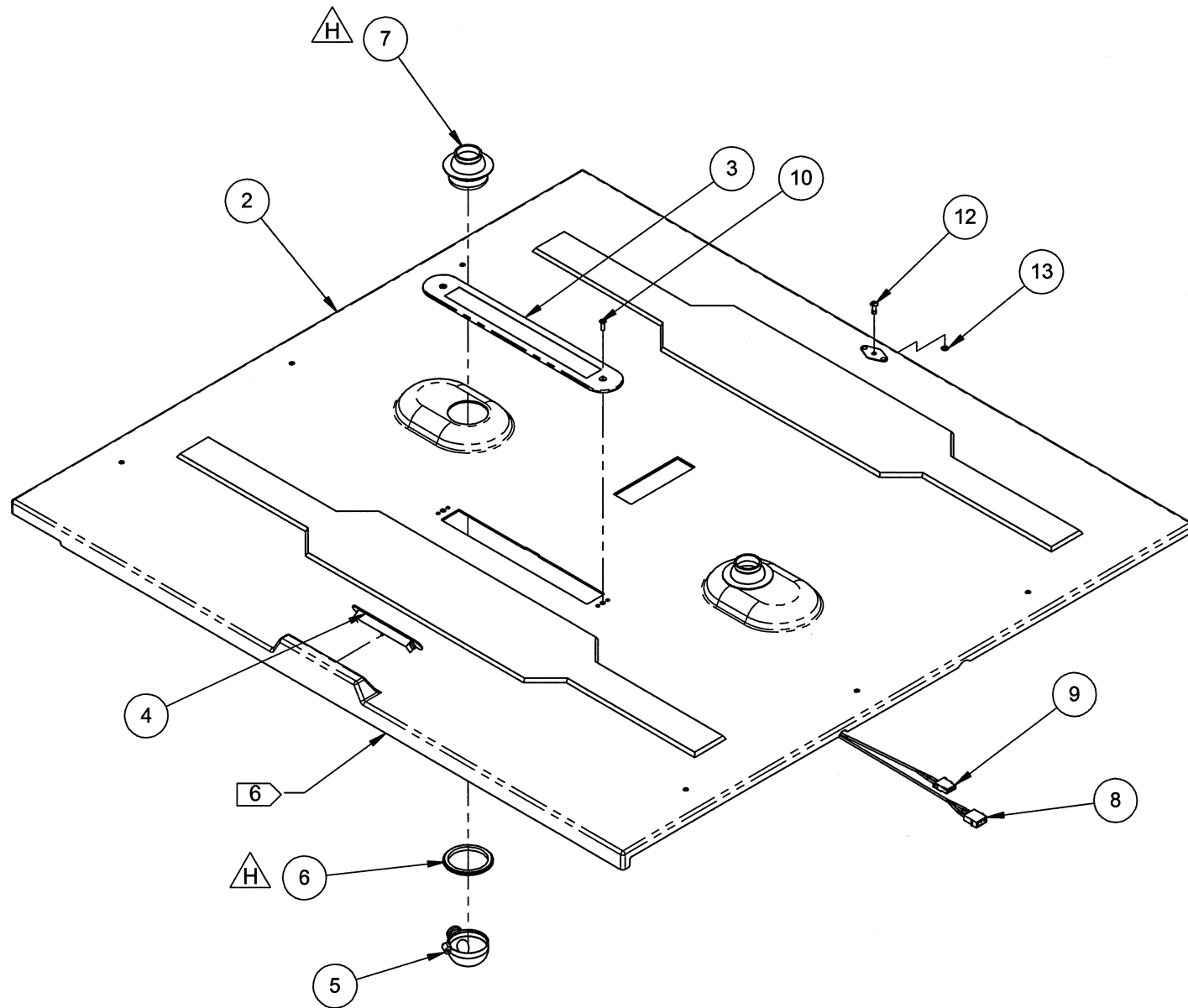
1

D

C

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ITEM NO.	QTY. -045	P/N	DESCRIPTION
1	X	D4634-045	AFT, CENTER CEILING PANEL ASSY
2	1	D4634-145	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-055)
4	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-049)
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-9 (REF)	MOUNTING NUT (PART OF D4652-7)
7	2	D4652-7	AIR VALVE
8	1	D4728-049	ADVISORY LIGHT (AFT) HARNESS ASSEMBLY
9	1	D4728-055	CABIN LIGHT #3 ASSEMBLY
10	2	N/A (REF)	SCREW (PART OF D4638-1)
11	10	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
12	1	2351-20-27-C3C	DZUS STUD, OVAL HEAD
13	1	50-009-2	GROMMET

D

C

B

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### D4634-045 AFT, CENTER CEILING PANEL ASSY

#### NOTES:

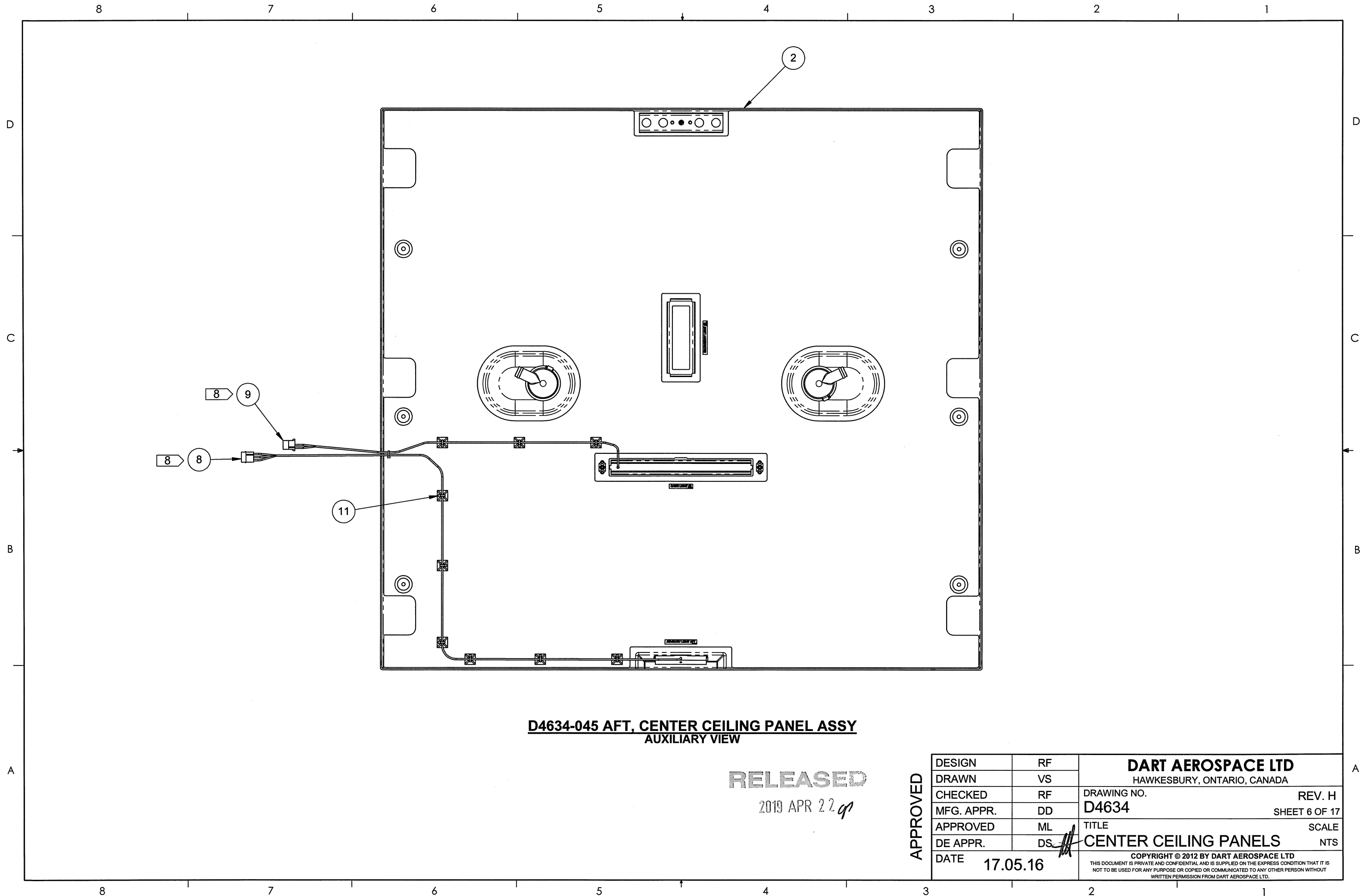
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 10.5 lbs
- 8) INSTALL D4728-049/-055 WIRE HARNESS PER QSI 048

**RELEASED**

2019 APR 22

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. H
MFG. APPR.	DD		SHEET 5 OF 17
APPROVED	ML	TITLE	SCALE
DE APPR.	DS	<b>CENTER CEILING PANELS</b>	NTS
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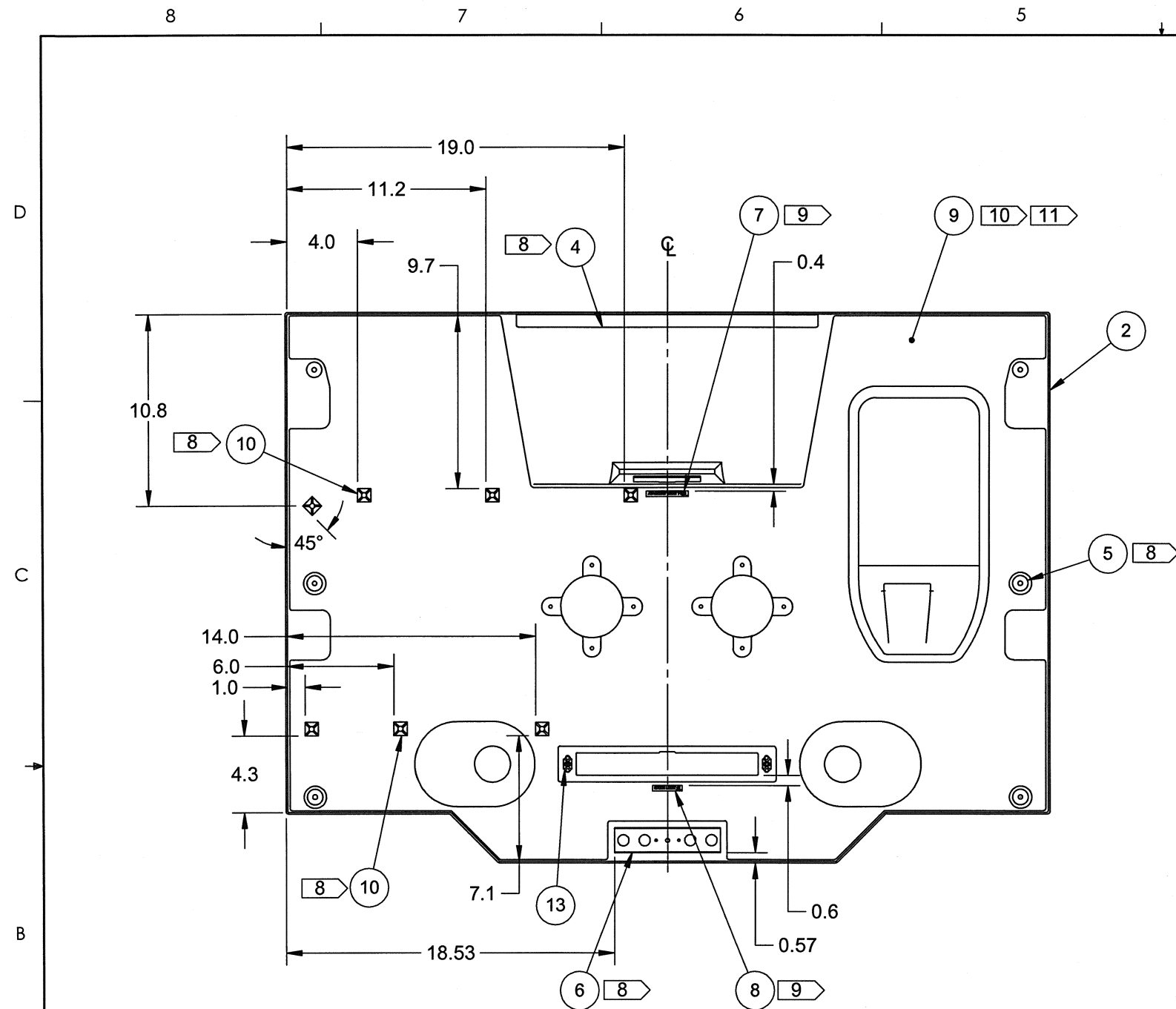


**D4634-045 AFT, CENTER CEILING PANEL ASSY**  
**AUXILIARY VIEW**

**RELEASED**  
 2019 APR 22 *qf*

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. H
MFG. APPR.	DD	<b>D4634</b>	SHEET 6 OF 17
APPROVED	ML	TITLE	SCALE
DE APPR.	DS	<b>CENTER CEILING PANELS</b>	NTS
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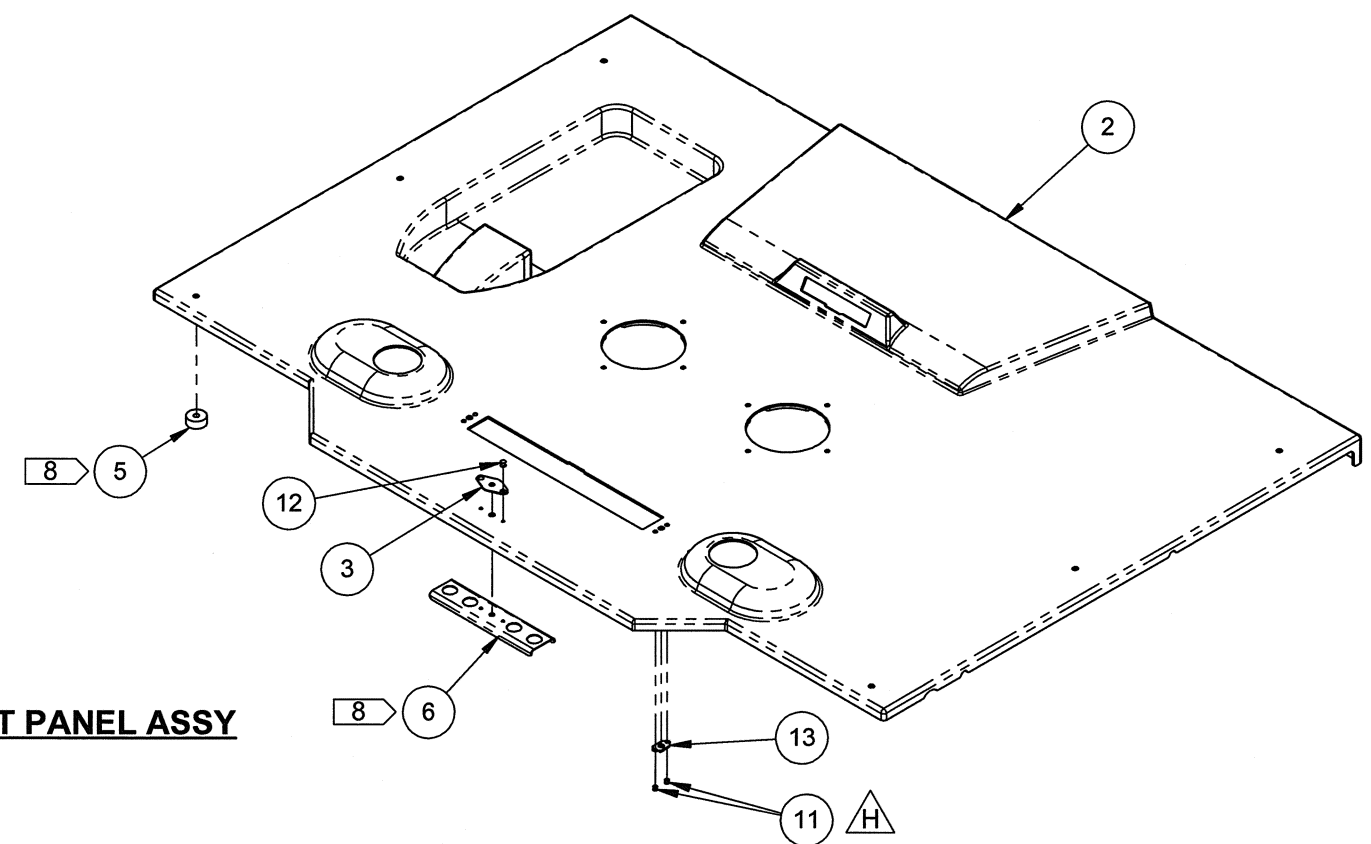
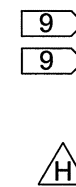
**D4634-141 FWD, CENTER CEILING REPLACEMENT PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4664-5, D4712-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-1 FOAM ON D4634-1

**RELEASED**

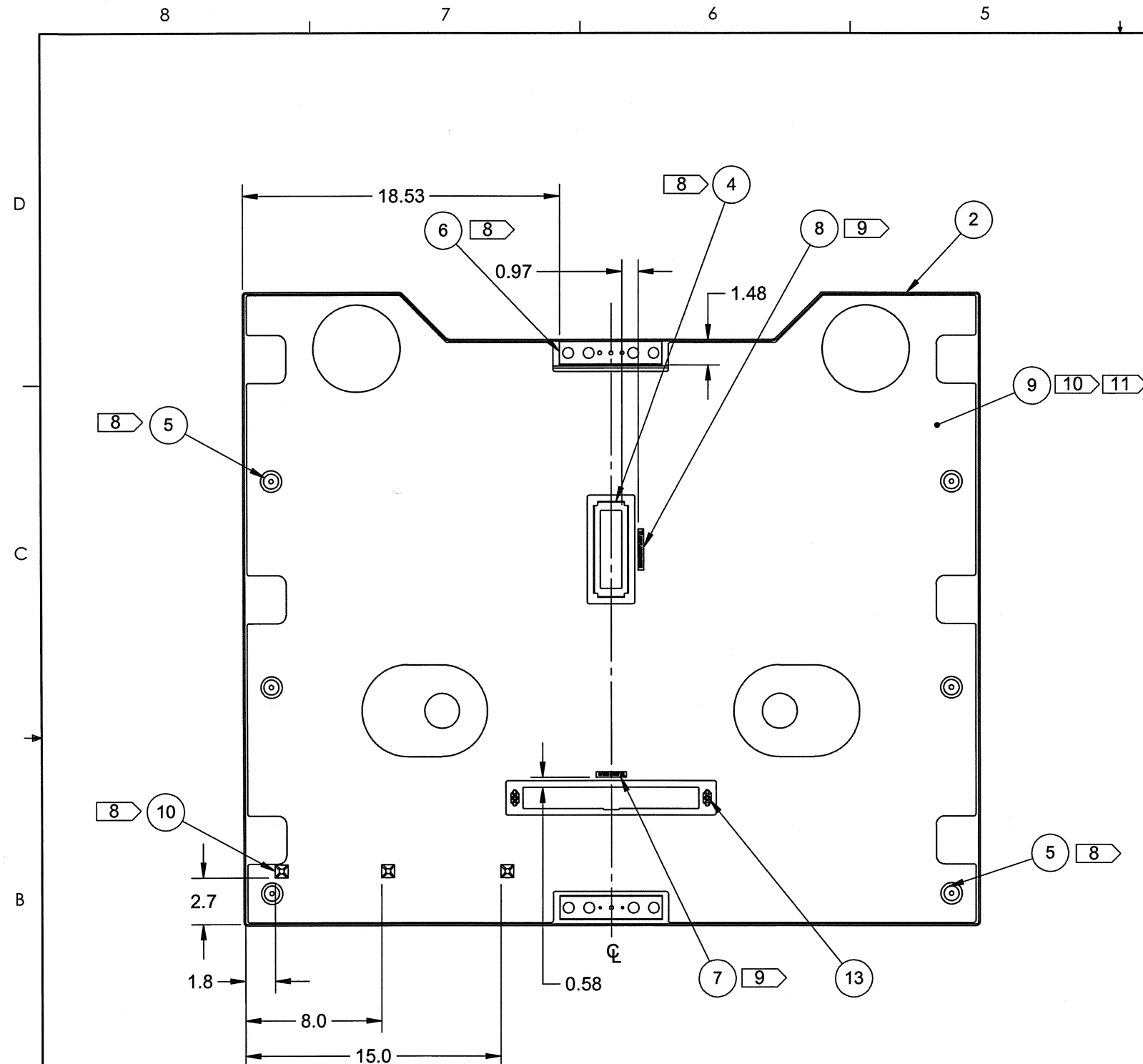
2019 APR 22



ITEM	QTY -141	P/N	DESCRIPTION
1	X	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-1	FWD, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-5	DOUBLER
5	6	D4664-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-15	LABEL
8	1	D4732-19	LABEL
9	1	D5021-1	FOAM, CENTER PANEL, FWD
10	7	MPNY-750S-9-C	MOUNTING PAD
11	4	CCR264SS-3-(03)	RIVET, BLIND, CSK
12	2	MS20426AD4-(6)	RIVET, SOLID, CSK
13	2	MS21059L08	NUT PLATE

APPROVED

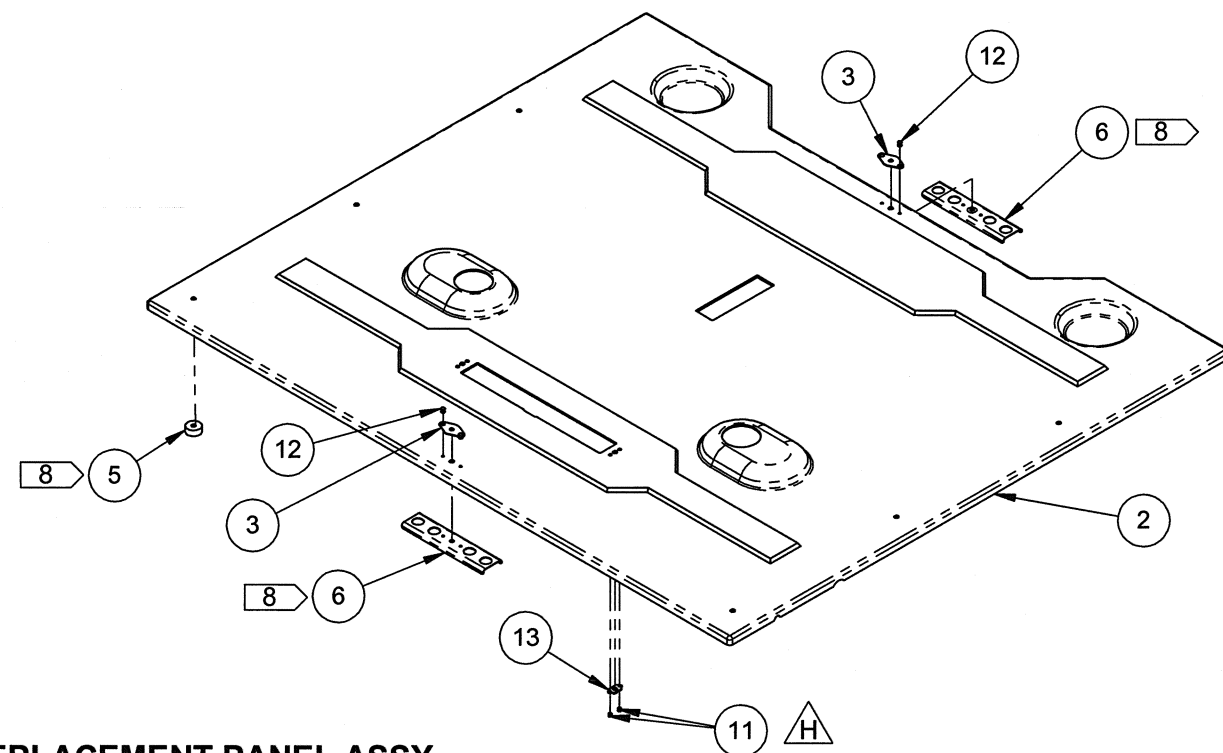
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. H
MFG. APPR.	DD		SHEET 7 OF 17
APPROVED	ML	TITLE	SCALE
DE APPR.	DS	<b>CENTER CEILING PANELS</b>	NTS
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**D4634-143 MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A
  - 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1, D4664-5 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
  - 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
  - 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-3 FOAM CORE TO INSIDE OF PANEL
  - 11) CENTER D5021-3 FOAM ON D4634-3

ITEM	QTY -143	P/N	DESCRIPTION
1	X	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-3	MIDDLE, CENTER CEILING PANEL
3	2	D4636-5	BRACKET
4	1	D4647-1	DOUBLER
5	6	D4664-5	SPACER
6	2	D4712-1	BRACKET
7	1	D4732-21	LABEL
8	1	D4732-25	LABEL
9	1	D5021-3	FOAM, CENTER PANEL, MIDDLE
10	3	MPNY-750S-9-C	MOUNTING PAD
11	4	CCR264SS-3-(03)	RIVET, BLIND, CSK
12	4	MS20426AD4-(6)	RIVET, SOLID, CSK
13	2	MS21059L08	NUT PLATE



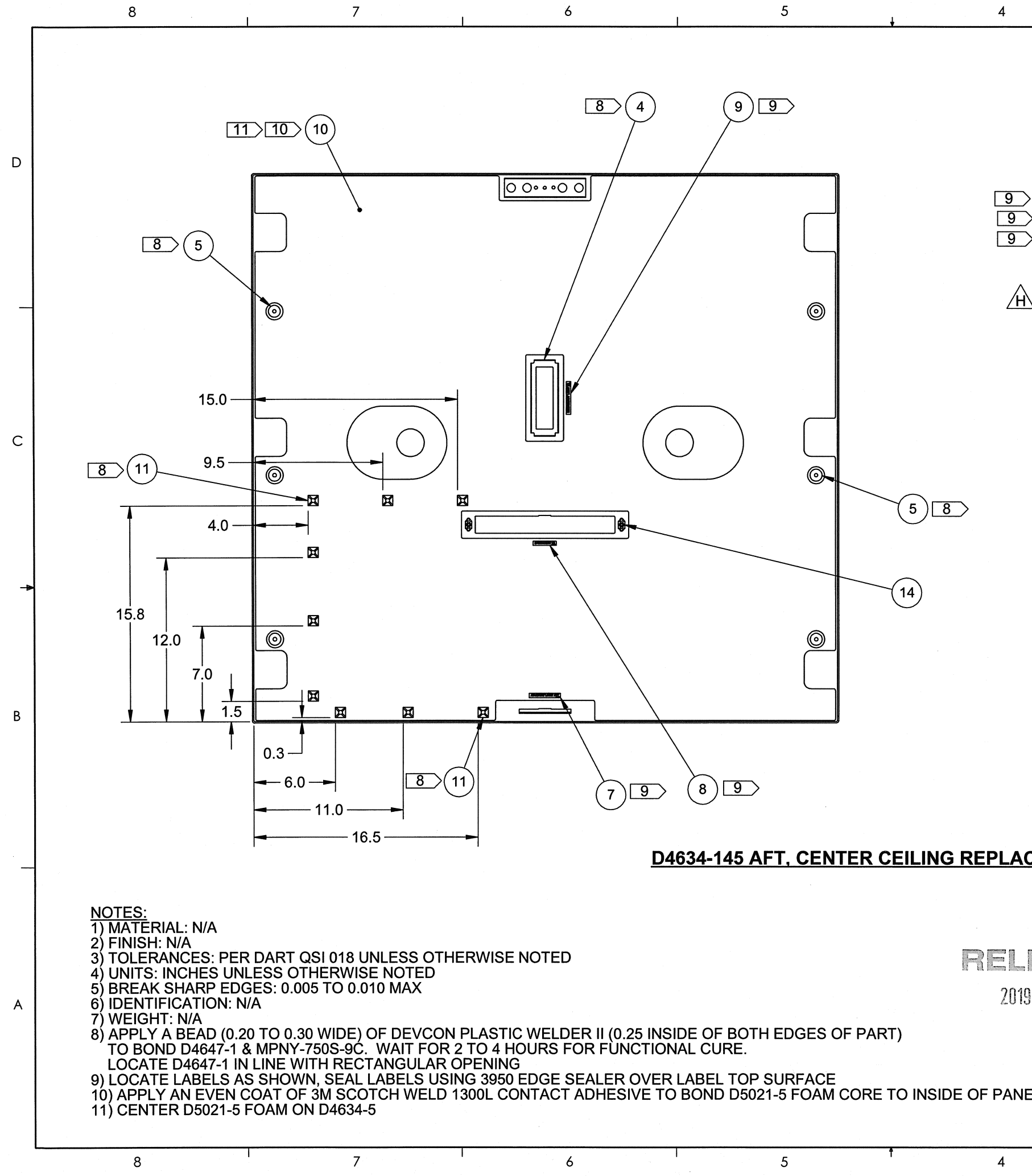
**RELEASED**

2019 APR 22

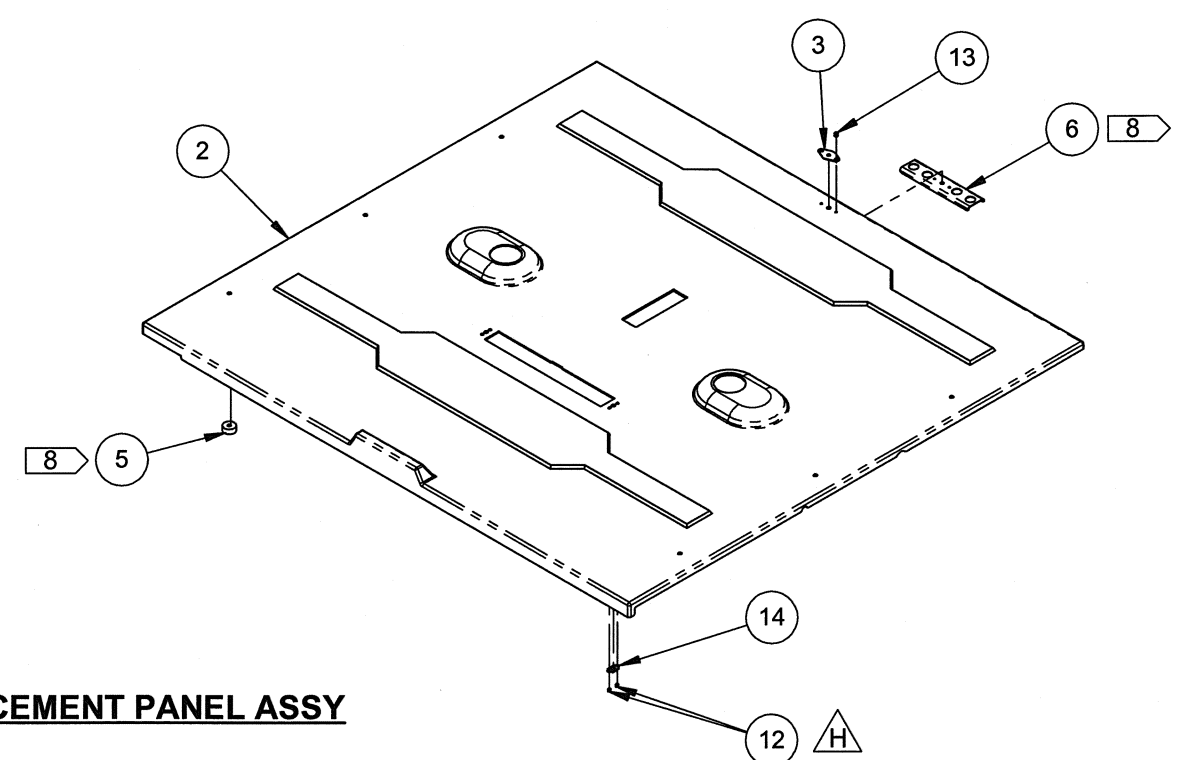
APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. H
MFG. APPR.	DD	SHEET 8 OF 17	
APPROVED	ML	TITLE	SCALE
DE APPR.	DS	<b>CENTER CEILING PANELS</b>	NTS
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ITEM	QTY -145	P/N	DESCRIPTION
1	X	D4634-145	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-5	AFT, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-1	DOUBLER
5	6	D4664-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-17	LABEL
8	1	D4732-23	LABEL
9	1	D4732-27	LABEL
10	1	D5021-5	FOAM, CENTER PANEL, AFT
11	9	MPNY-750S-9-C	MOUNTING PAD
12	4	CCR264SS-3-(03)	RIVET, BLIND, CSK
13	2	MS20426AD4-(6)	RIVET, SOLID, CSK
14	2	MS21059L08	NUT PLATE



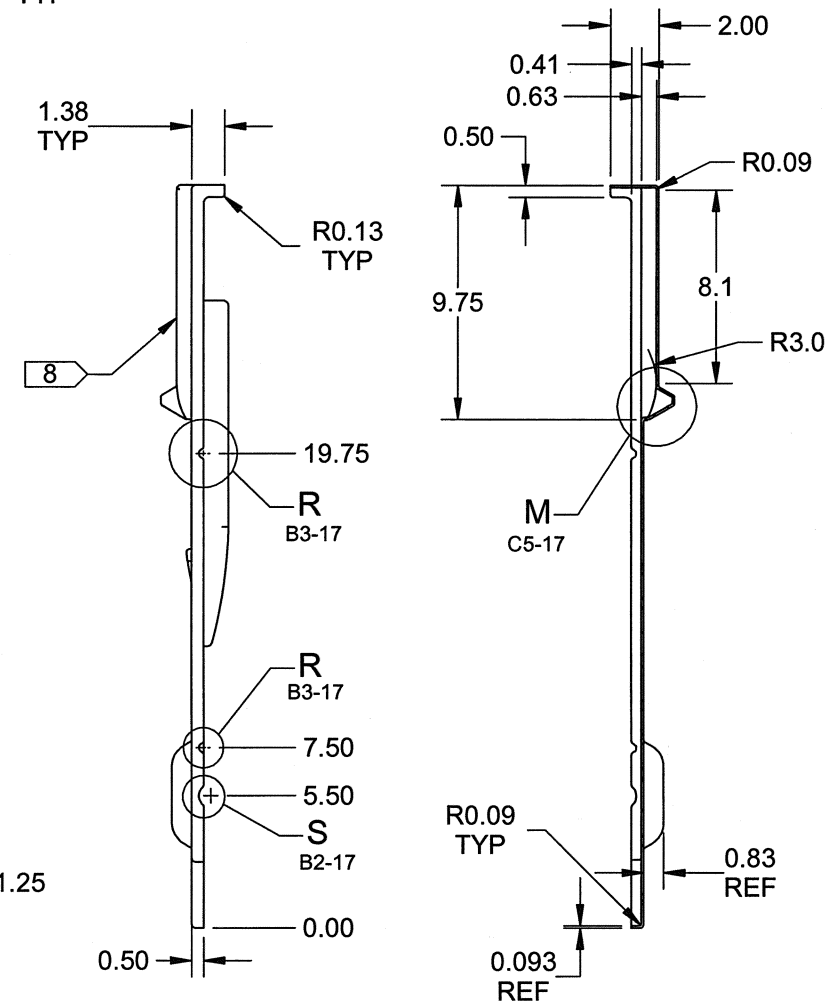
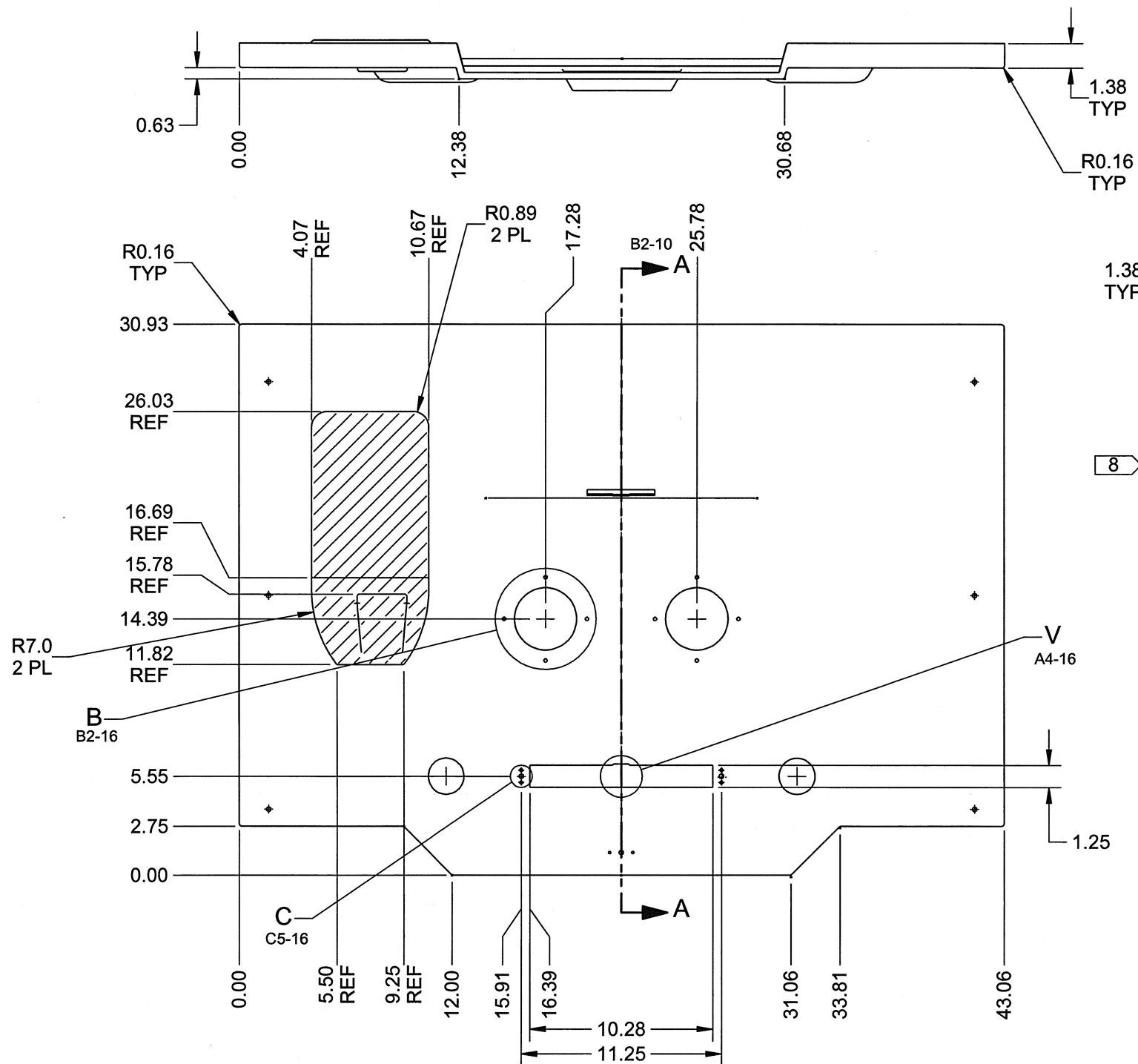
**D4634-145 AFT, CENTER CEILING REPLACEMENT PANEL ASSY**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A
  - 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.  
LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
  - 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
  - 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-5 FOAM CORE TO INSIDE OF PANEL
  - 11) CENTER D5021-5 FOAM ON D4634-5

RELEASED  
2019 APR 22

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. H
MFG. APPR.	DD	SHEET 9 OF 17	
APPROVED	ML	TITLE	SCALE
DE APPR.	DS	<b>CENTER CEILING PANELS</b>	NTS
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**SECTION A-A** C6-10

- NOTES:**
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 5.65 lbs
  - 8) TEXTURE ON THIS SIDE
  - 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
  - 10) DRILL & TRIM D4634-1 PER TOOL DT9836
  - 11) THERMOFORM PER QSI 022 USING DT9844 TOOL  
MIN. THICKNESS AFTER FORMING:  
SHADED AREA = 0.020  
EDGES = 0.060  
ELSEWHERE = 0.070
  - 12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

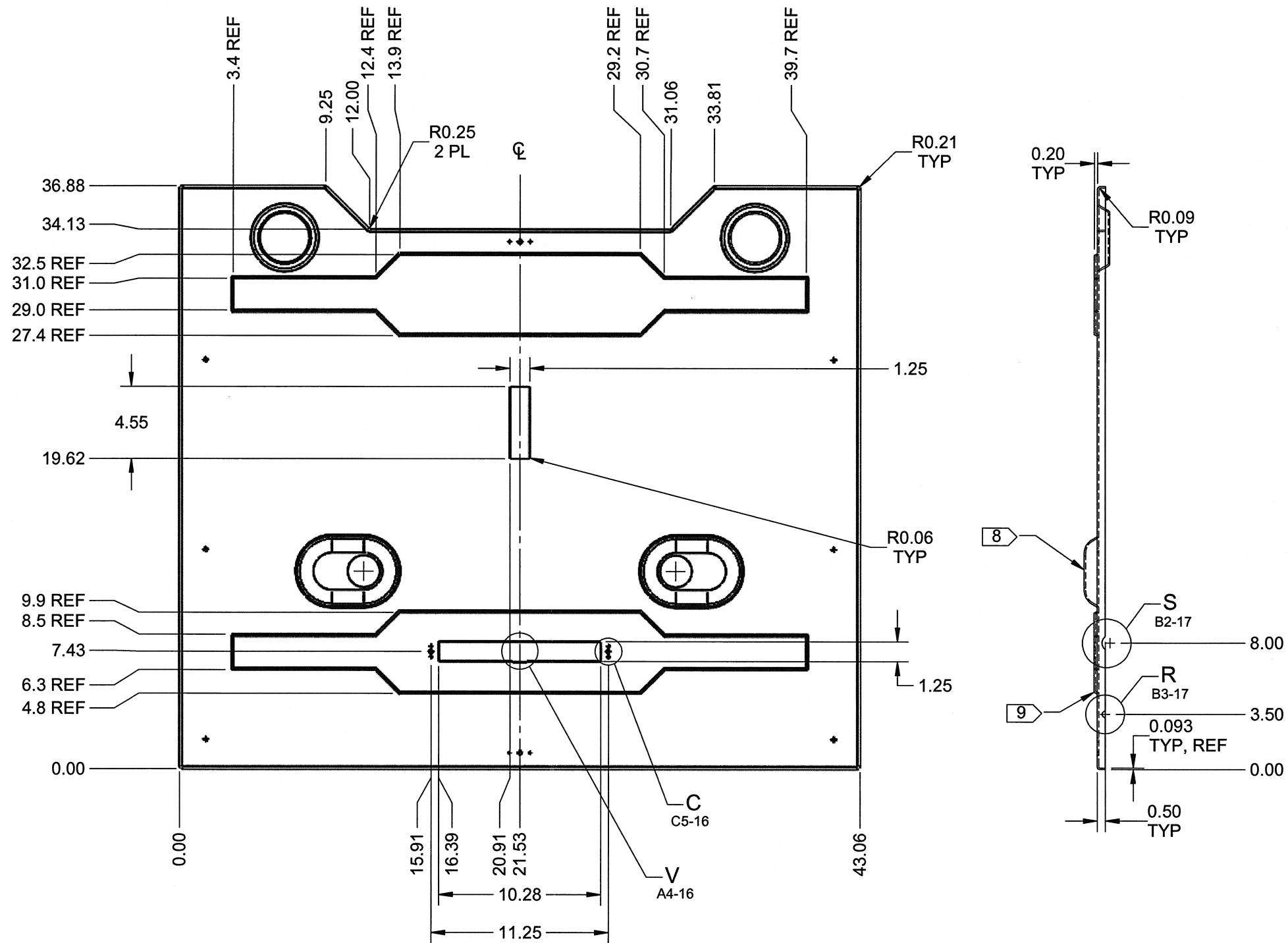
**D4634-1 FWD, CENTER CEILING PANEL**

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2019 APR 22

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. H
MFG. APPR.	DD	SHEET 10 OF 17	
APPROVED	ML	TITLE	SCALE
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# NOTES:

1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-07)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 6.49 lbs

8) TEXTURE ON THIS SIDE

9) 0.14 RADIUS NOT SHOWN FOR CLARITY

10) DRILL & TRIM D4634-3 PER TOOL DT9837

11) THERMOFORM PER QSI 022 USING DT9845 TOOL

MIN. THICKNESS AFTER FORMING:

EDGES = 0.060

ELSEWHERE = 0.070

12) LOCATE  $\varnothing$ 2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

## **D4634-3 MIDDLE, CENTER CEILING PANEL**

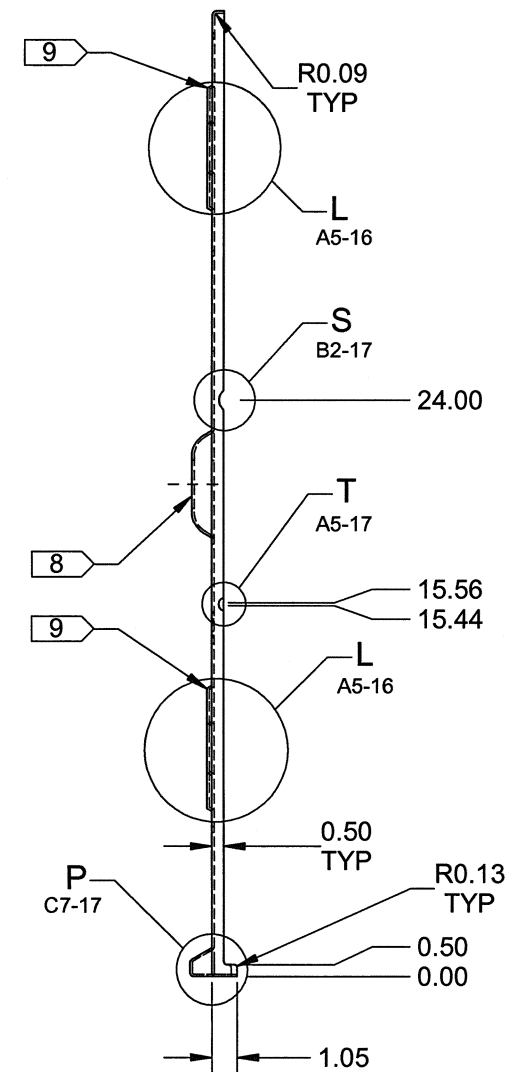
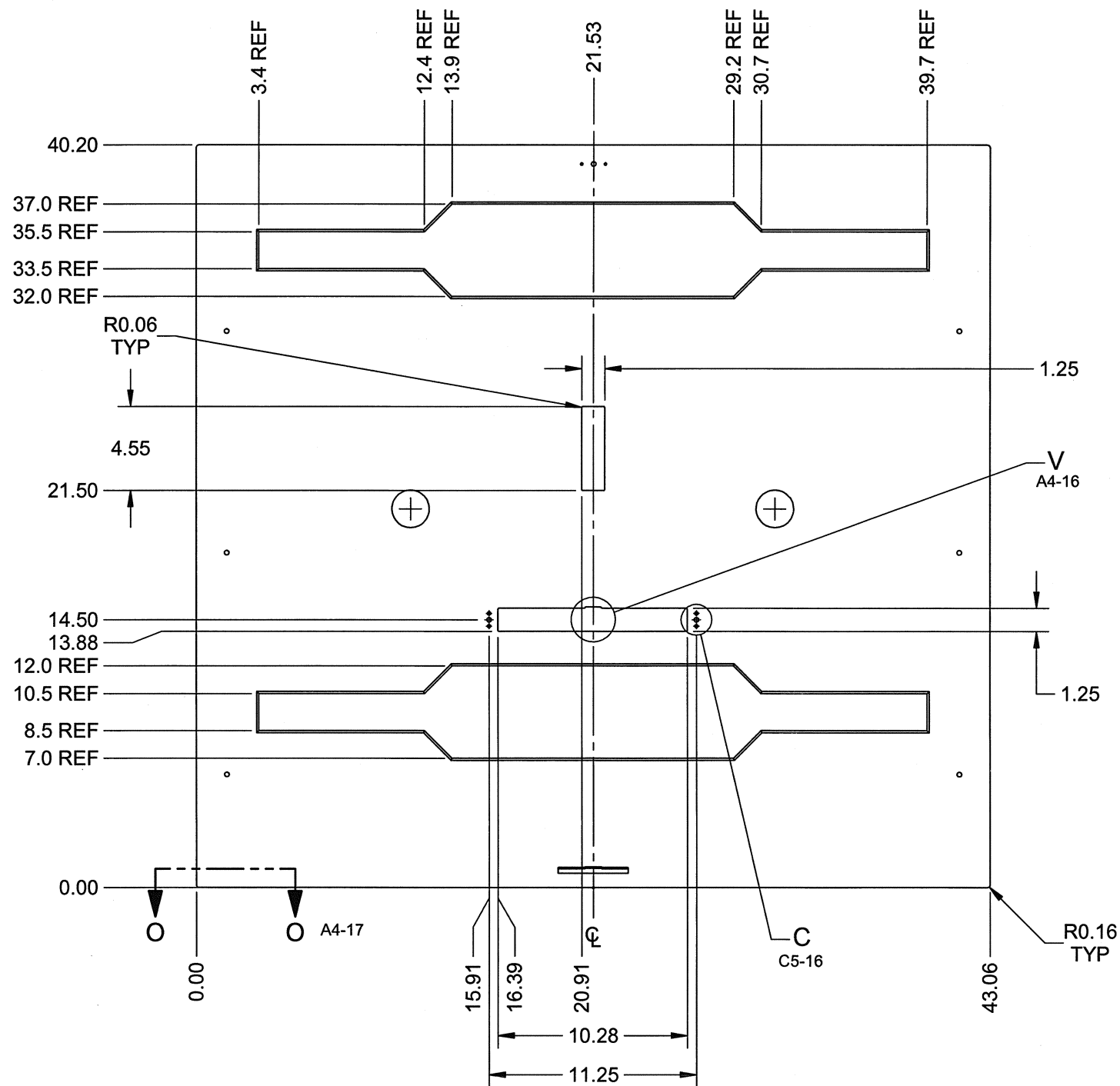
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MFG. APPR.	DD	<b>D4634</b>	SHEET 12 OF 17
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# NOTES:

1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-07)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 7.39 lbs

8) TEXTURE ON THIS SIDE

9) 0.14 RADIUS NOT SHOWN FOR CLARITY

10) DRILL & TRIM D4634-5 PER TOOL DT9838

11) THERMOFORM PER QSI 022 USING DT9846 TOOL

MIN. THICKNESS AFTER FORMING:

EDGES = 0.060

ELSEWHERE = 0.070

12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

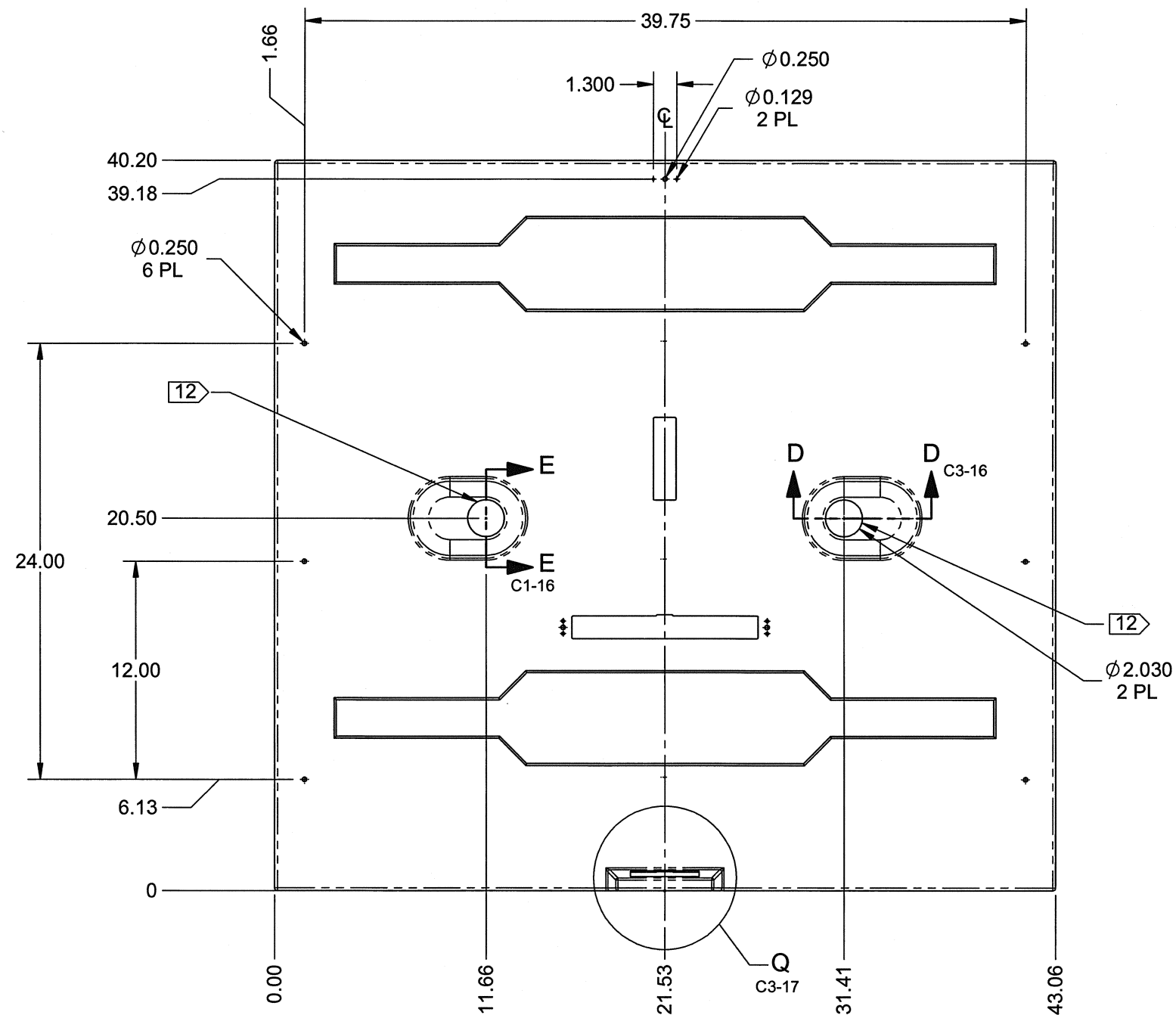
## D4634-5 AFT, CENTER CEILING PANEL

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**D4634-5 AFT, CENTER CEILING PANEL**  
AUXILIARY VIEW

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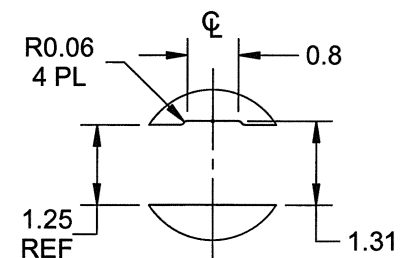
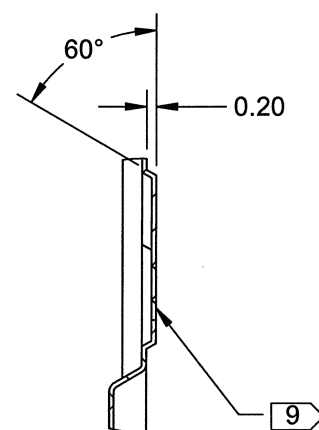
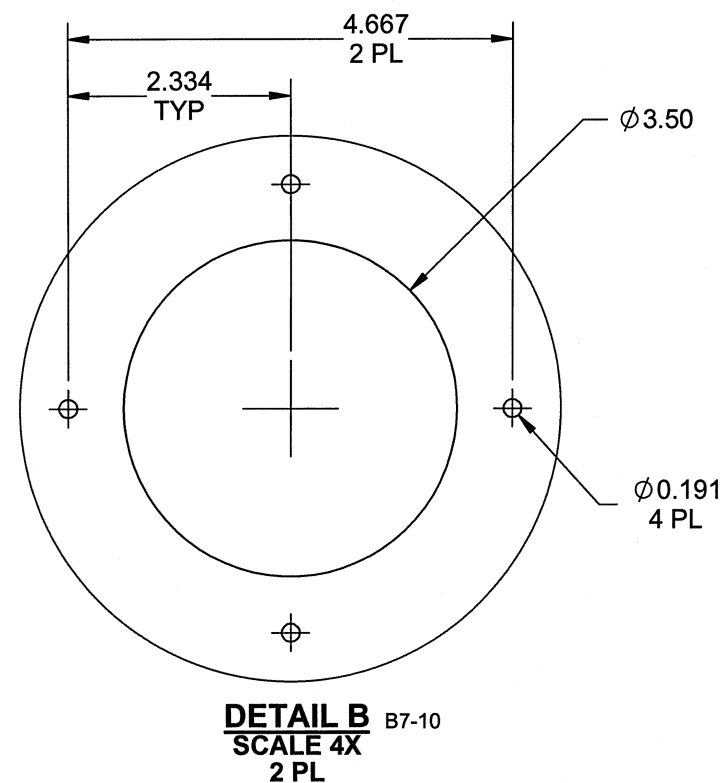
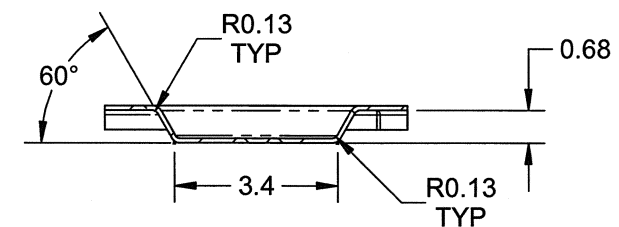
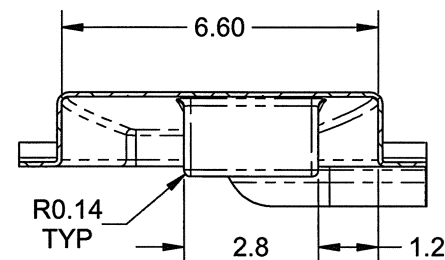
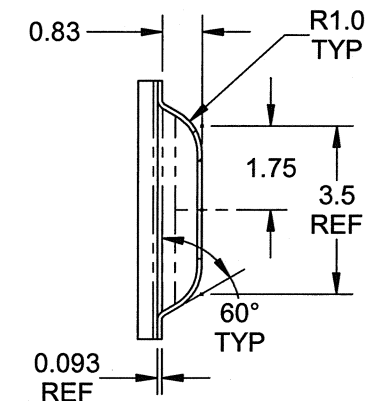
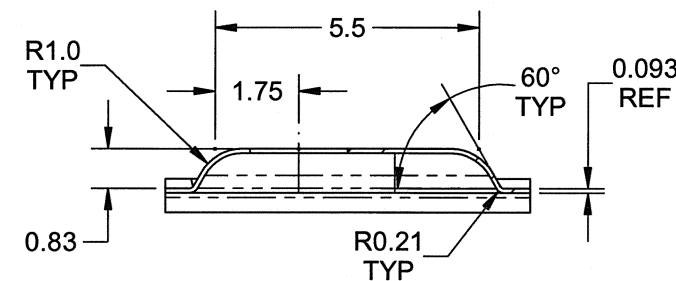
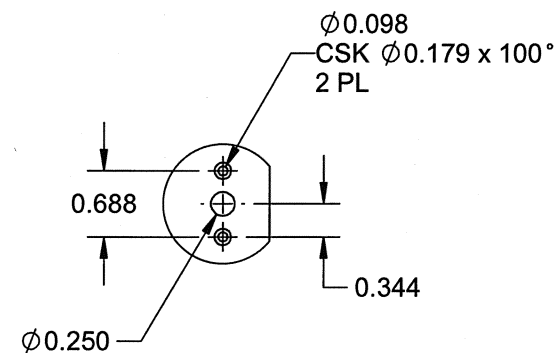
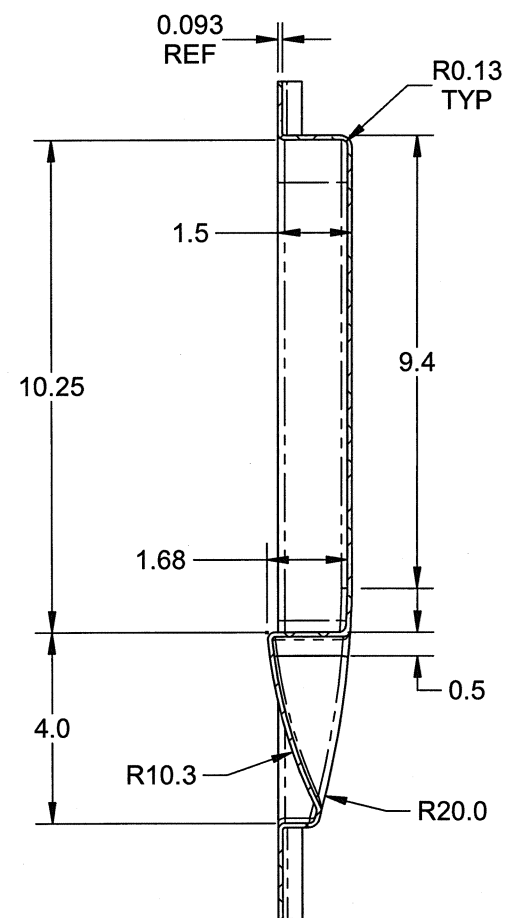
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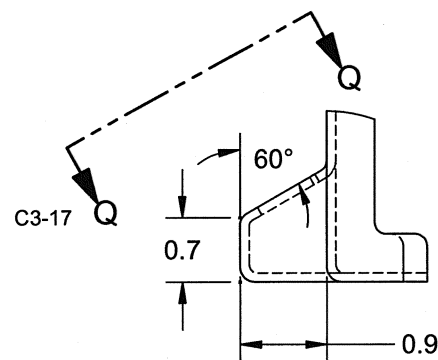
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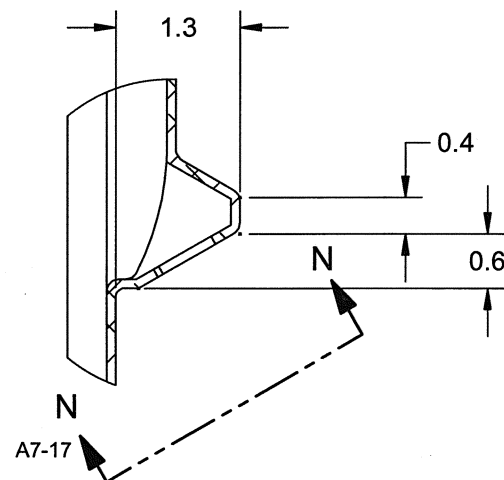
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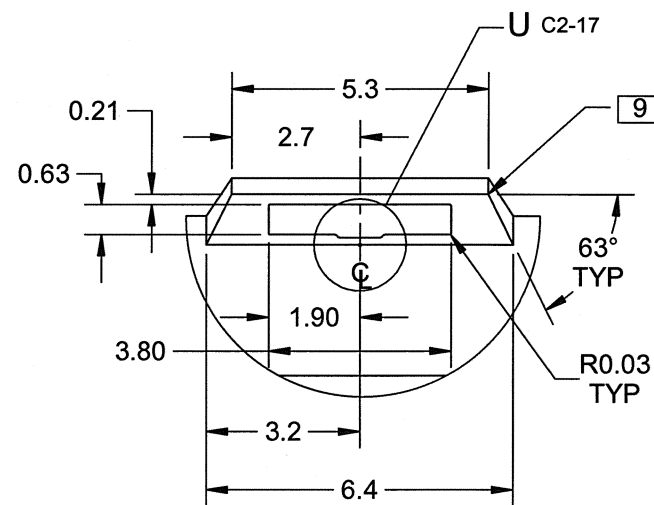




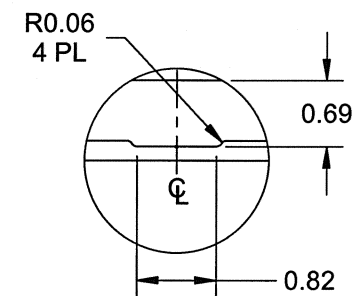
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SCALE 2X B3-14



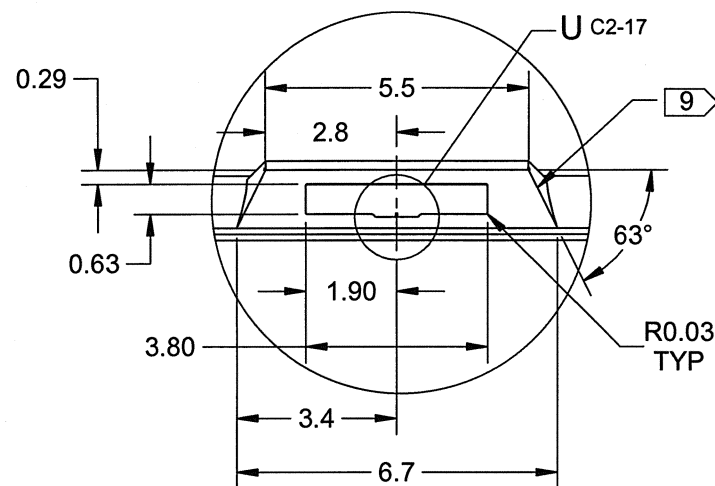
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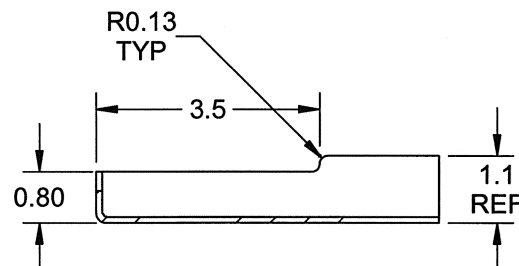
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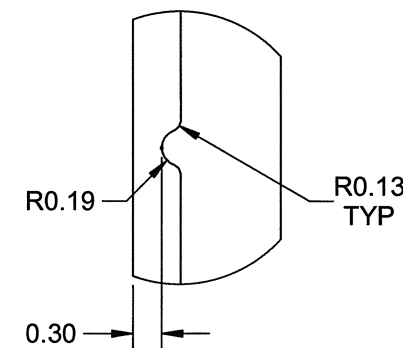
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SCALE 0.5X B7-17  
D3-17



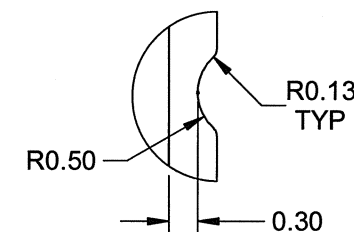
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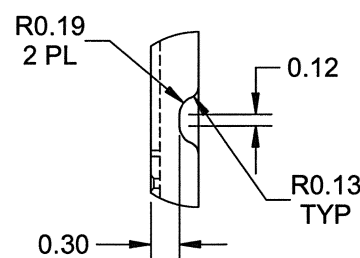
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**DETAIL R**  
SCALE 4X B3-10  
C3-10  
B2-12



**DETAIL S**  
SCALE 4X B3-10  
C2-12



**DETAIL T**  
SCALE 4X C2-14

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